

Work Order ID **53837-1**

November 19, 2009 9:04:16 AM

Page 1

Item ID: D3648-041

Accept

Revision ID: B

Item Name: Driveshaft Tunnel Assembly

Start Date: 10/11/2009 Start Qty: 2.00

Required Date: 25/11/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *RP*

Date: *09/11/09* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3648

Rev B

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

*SB 10/00/05*

110

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D3648 2- Seal mating surface and all gaps as per dwg D3648 with ☐ Proseal 700 fire wall sealant ☐ batch: *M110624*

*EP 10/05/05 @*

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*SB 10/05/05*

*40*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 53837

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Item ID: D3648-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Driveshaft Tunnel Assembly

Start Date: 19/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00							
140  QC Quality Control	QC21 - Final Inspection - Work Order Release  Memo	0.00  0.00							

10/8/09 sf 10

10/08/09 df  
MVF  
10-8-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

November 19, 2009 9:04:24 AM

Work Order ID: 53837

Parent Item: D3648-041RevB

Parent Item Name: Driveshaft Tunnel Assembly

Comments:

Start Date: 19/11/2009

Required Date: 25/11/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960C10

Purchased

No

100

Each

231.0000

80.0000

WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

231

111965

231

AN3C3A

Purchased

No

110

Each

513.0000

80.0000

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

513

110715

50

111916

463

D3649-041RevB

Manufactured

No

110

Each

0.0000

2.0000

Tunnel Bottom Panel Assembly

D3650-041RevC

Manufactured

No

110

Each

0.0000

2.0000

Tunnel Top Panel Assembly

D3651-041RevB

Manufactured

No

110

Each

0.0000

2.0000

Aft Base Assembly

80 10/08/05

80

80 10/08/05

80

85 10/08/05

80

10/08/05

85 10/08/05

B 52 638

B 53 919

B 52081

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

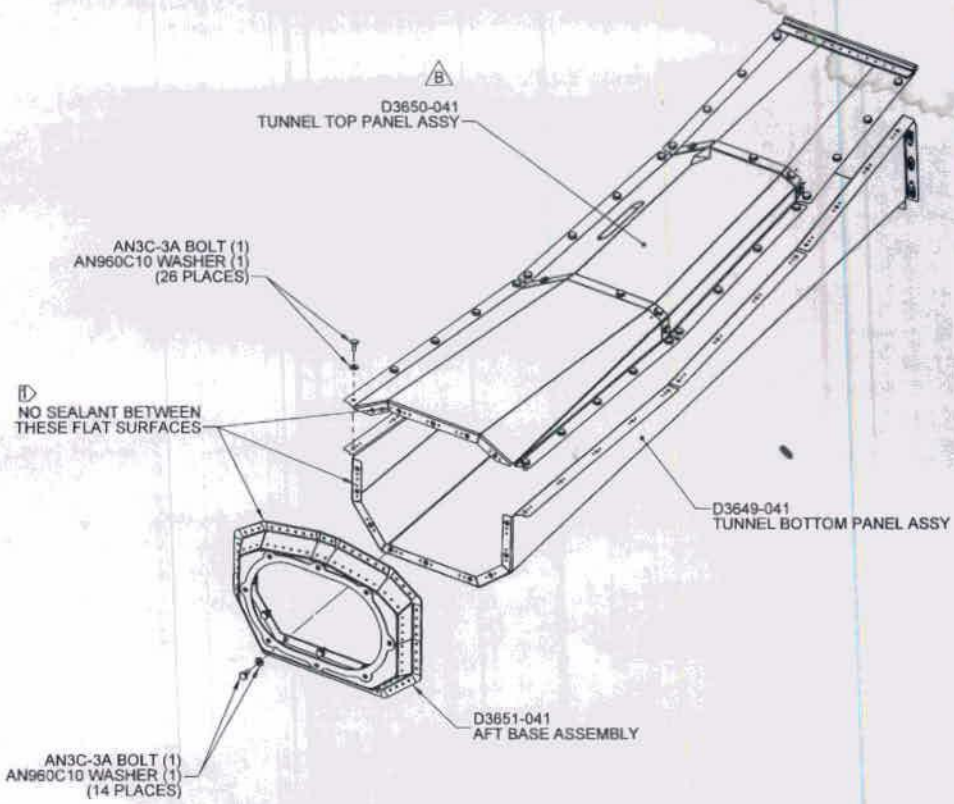
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

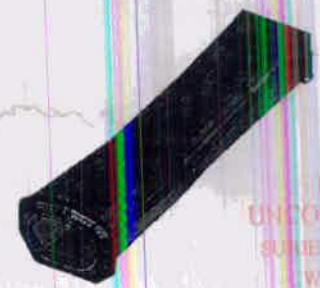
**NOTE:** Date & initial all entries





**D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY**

- NOTES:**
- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
  - 7) TORQUE FASTENERS TO 15-25 in-lb
  - 8) WEIGHT: 9.2 lbs



STOP  
RETURN  
ISSUED  
UNCONTROLLED  
SUBJECT TO  
WITHOUT  
WORK  
NO. 53832

**PART LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED  
07-03-27

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3648	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DRIVE SHAFT TUNNEL ASSY	1:8
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	

